Table A1
Guide to the Choice of Filler Metal for General Purpose Welding

Base Metal	Base Metal: AM100A	AZ10A	AZ31B AZ31C	AZ61A	AZ63A	AZ80A	AZ81A	AZ91C	AZ92A	EK41A	EZ33A	HK31A
	Filler Metal[a,b]											
AM100A	AZ101A AZ92A											
AZ10A	AZ92A	AZ61A AZ92A										
AZ31B AZ31C	AZ92A	AZ61A AZ92A	AZ61A AZ92A									
AZ61A	AZ92A	AZ61A AZ92A	AZ61A AZ92A	AZ61A AZ92A								
AZ63A	c	c	c	c	AZ101A AZ92A							
AZ80A	AZ92A	AZ61A AZ92A	AZ61A AZ92A	AZ61A AZ92A	c	AZ61A AZ92A						
AZ81A	AZ92A	AZ92A	AZ92A	AZ92A	c	AZ92A	AZ101A AZ92A					
AZ91C	AZ92A	AZ92A	AZ92A	AZ92A	c	AZ92A	AZ92A	AZ101A AZ92A				
AZ92A	AZ92A	AZ92A	AZ92A	AZ92A	c	AZ92A	AZ92A	AZ92A	AZ101A			
EK41A	AZ92A	AZ92A	AZ92A	AZ92A	c	AZ92A	AZ92A	AZ92A	AZ92A	EZ33A		
EZ33A	AZ92A	AZ92A	AZ92A	AZ92A	c	AZ92A	AZ92A	AZ92A	AZ92A	EZ33A	EZ33A	
HK31A	AZ92A	AZ92A	AZ92A	AZ92A	c	AZ92A	AZ92A	AZ92A	AZ92A	EZ33A	EZ33A	EZ33A
HM21A	AZ92A	AZ92A	AZ92A	AZ92A	c	AZ92A	AZ92A	AZ92A	AZ92A	EZ33A	EZ33A	EZ33A
HM31A	AZ92A	AZ92A	AZ92A	AZ92A	c	AZ92A	AZ92A	AZ92A	AZ92A	EZ33A	EZ33A	EZ33A
HZ32A	AZ92A	AZ92A	AZ92A	AZ92A	c	AZ92A	AZ92A	AZ92A	AZ92A	EZ33A	EZ33A	EZ33A
K1A	AZ92A	AZ92A	AZ92A	AZ92A	c	AZ92A	AZ92A	AZ92A	AZ92A	EZ33A	EZ33A	EZ33A
LA141A	d	d	EZ33A	c	c	c	c	c	c	d	d	d
M1A MG1	AZ92A	AZ61A AZ92A	AZ61A AZ92A	AZ61A AZ92A	c	AZ61A AZ92A	AZ92A	AZ92A	AZ92A	AZ92A	AZ92A	AZ92A
QE22A	d	d	AZ92A	d	c	d	d	d	d	EZ33A	EZ33A	EZ33A
ZE10A	AZ92A	AZ61A AZ92A	AZ61A AZ92A	AZ61A AZ92A	c	AZ61A AZ92A	AZ92A	AZ92A	AZ92A	EZ33A AZ92A	EZ33A AZ92A	EZ33A AZ92A
ZE41A	d	d	d	d	c	d	d	d	d	EZ33A	EZ33A	EZ33A
ZK21A	AZ92A	AZ61A AZ92A	AZ61A AZ92A	AZ61A AZ92A	c	AZ61A AZ92A	AZ92A	AZ92A	AZ92A	AZ92A	AZ92A	AZ92A
ZH62A ZK51A ZK60A ZK61A	c	c	c	c	c	c	c	c	c	c	c	c

(continued)

Table A1 (continued)

Basc Metal	Base Metal: HM21A	HM31A	HZ32A	K1A	LA141A	M1A MG1	QE22A	ZE10A	ZE41A	ZK21A	ZH62A ZK51A ZK60A ZK61A
	Filler Metal[a,b]										
HM21A	EZ33A										
HM31A	EZ33A	EZ33A									
HZ32A	EZ33A	EZ33A									
K1A	EZ33A	EZ33A	EZ33A	EZ33A							
LA141A	EZ33A	d	d	d	EZ33A						
M1A, MG1	AZ92A	AZ92A	AZ92A	AZ92A	d	AZ61A, AZ92A					
QE22A	EZ33A	EZ33A	EZ33A	EZ33A	EZ33A	c	EZ33A				
ZE10A	EZ33A, AZ92A	EZ33A, AZ92A	EZ33A, AZ92A	EZ33A, AZ92A	EZ33A	AZ61A, AZ92A	EZ33A, AZ92A	AZ61A, AZ92A			
ZE41A	EZ33A	EZ33A	EZ33A	EZ33A	d	d	EZ33A	d	EZ33A		
ZK21A	AZ92A	AZ92A	AZ92A	AZ92A	d	AZ61A, AZ92A	AZ92A	AZ61A, AZ92A	AZ92A	AZ61A, AZ92A	
ZH62A, ZK51A, ZK60A, ZK61A	c	c	c	c	c	c	c	c	c	c	EZ33A

Notes:

a. When more than one filler metal is given, they are listed in order of preference.

b. The letter prefix (ER or R), designating usability of the filler metal, has been deleted, to reduce clutter in the table.

c. Welding not recommended.

d. No data available.